

3M™ Scotchkote™ WB Epoxy Spray Filler 015

Data Sheet and Application Guide

Product Description

Scotchkote WB Epoxy Spray Filler 015 has been specifically developed for use as a high build spray filler for use in conjunction with Scotchkote water-borne systems used predominantly within the rail industry.

Product Features

- Combines good application characteristics with excellent sanding properties.
- Excellent speed of drying.

General Application Steps

1. Surfaces should first be primed with 3M™ Scotchkote™ WB Epoxy Primer EA9WB.
2. Apply Scotchkote WB Epoxy Spray Filler 015 at the required thickness.
3. Allow to cure.
4. Visually or electrically inspect the coating for defects.
5. Repair all defects.

Properties

Property	Value
Colour	Buff
Ratio	6:1 by volume
Drying & Cure times at 20°C (68°F)	
Usable Life	30 mins
Sanding Time	3 hours
Overcoating Minimum	1 hour (with WB Epoxy Spray Filler) 4 hours (with WB Epoxy Coating EA9WB)
Maximum	3 months
Full Cure	7 days
Volume Solids	50%
Specific Gravity (Average Mixed)	1.55
V.O.C (As Supplied)	40g/litre
Note: Thinning for spray application will reduce the applied V.O.C	
Film Thickness (Typical)	Wet 200 microns. Dry 100 microns
Theoretical Coverage Rate	7.5 sq metres per litre at 60 microns dft.



Application Procedures for 3M™ Scotchkote™ WB Epoxy Spray Filler 015

Surface Preparation

All surfaces should be appropriately prepared then primed with 3M™ Scotchkote™ WB Epoxy Coating EA9WB.

Application Procedures

Mixing

Stir the contents of the Part A component. Continue stirring whilst gradually adding the total contents of the Part B container. Continue stirring until a homogeneous mix is obtained.

Note When mixing complete units of product, the use of a slow or variable speed mechanical mixer is beneficial in terms of ease and complete mixing.

Application

- Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3°C above the dew point.
- For optimum results a minimum material and substrate temperature of 15°C is necessary.
- Primed surfaces should be clean, dry and free from oil and grease.

Method

3M Scotchkote WB Epoxy Spray Filler 015 can be applied by airless or air assisted airless spray. Small additions of clean water (up to 5% by volume) may be required when using air assisted airless spray.

Handling and Safety Precautions

Read all health hazard, precautionary and first aid statements found in the Material Safety Data Sheet, and/or product label prior to handling or use.

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The product should be applied in multiple passes to provide a wet film thickness of 150-250 microns. Once adequately dried a further coat may be applied to build up to a smooth level surface.

Ideally dedicated spray equipment should be used for applying waterborne coatings. If this is not possible, equipment should be first flushed with a solvent related to the previous solvent based coating. This should then be followed by a second flushing using 3M™ Scotchkote™ Cleaner 3000 then by rinsing through with clean water. After use, wash out with clean water followed by flushing with Scotchkote Cleaner 3000.

Typical Spray Settings are:

Airless Spray Tip Size 15 - 25 thou

Tip Pressure 3000-3500psi

Note: When airless spray is being used, excessively high tip spraying pressures should be avoided. The minimum pressure at the pump conducive with good atomisation should be used.

Packaging and Storage

Supplied in 10 kilo packs.

Use within 1 year of date of manufacture. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F). Protect from frost during storage and use.

Ordering Information/Customer Service

For ordering, technical and product information or to request a copy of the Material Safety Data Sheet, call +44 (0)1609 780170 or fax +44 (0)1609 783762 (Sales) or 788718 (Technical).

For emergencies, please contact +44 (0)1344 858000.



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